

Date: Wednesday, 28/05/2008 1:53:42 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	TURNING DETAIL FOR D2893-1	
<b>Job Number</b> :	39539	<b>Part Number</b> :	DSK078	
<b>Estimate Number</b> :	13234	<b>Drawing Number</b> :	DSK078 REV.A	
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A	
<b>This Issue</b> :	28/05/2008	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Revision</b> :	A	
<b>First Issue</b> :	1/1	<b>Type</b> :	MACHINED PARTS	
<b>Previous Run</b> :	39066	<b>Material</b> :		
<b>Written By</b> :		<b>Due Date</b> :	06/06/2008	<b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	<u>JLD 08-5-28</u>			
<b>Comment</b> :	est rev A. 08.03.13 new issue EC			

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6104005	Round Billet, 17-4
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
 Support

*Prk 08/05/29*

10

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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**Comment:** MORI SEIKI CNC LATHE LARGE  
 Turn blank as per Folio FA081

*Batch: B38688*

*Prk 08/05/29 / 20 08/05/31*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*Prk 08/05/29 / 20 08/05/31*

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

*88 08/05/31*

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Identify and Stock in Kanban  
 Location: *CNC*

*26 08/05/31*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 28/05/2008 1:53:42 PM  
User: \ Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TURNING DETAIL FOR D2893-1

Job Number: 39539

Part Number: DSK078

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/03 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*h 08-06-03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	39539
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078		Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.711	2.707	2.707	2.707	2.707
B	4.946	4.966		4.949	4.956	4.956	4.956	4.956
C	3.064	3.084		3.074	3.074	3.074	3.074	3.074
D	0.718	0.738		.727	.728	.728	.728	.726
E	0.090	0.110		.102	.102	.102	.102	.102
F	2.934	2.954		2.945	2.944	2.945	2.945	2.945
G	2.166	2.186		2.174	2.174	2.174	2.174	2.174
H	3.890	3.910		3.899	3.900	3.900	3.900	3.900
I	0.914	0.934		.929	.929	.929	.929	.929
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.120	.120	.120	.120	.120
L								
M								
N								
O								
P								

Measured by:	<i>ML 1.29</i>	Date:	05/05/29
Audited by:	<i>847</i>	Date:	08/05/31
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	59539
<b>Description:</b> Turning Detail for D2893-1		<b>Part Number:</b>	DSK078
<b>Inspection Dwg:</b> DSK078		<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

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C	3.064	3.084		3.074	3.074	3.074	3.074	3.074
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.102	.102	.102	.102	.102
F	2.934	2.954		2.945	2.945	2.945	2.945	2.945
G	2.166	2.186		2.174	2.174	2.174	2.174	2.174
H	3.890	3.910		3.900	3.900	3.900	3.900	3.900
I	0.914	0.934		.929	.929	.929	.929	.929
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.120	.120	.120	.120	.120
L								
M								
N								
O								
P								

<b>Measured by:</b>	20	<b>Date:</b>	08/05/31
<b>Audited by:</b>	S.F.	<b>Date:</b>	08/05/31
<b>Prototype Approval:</b>	N/A	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

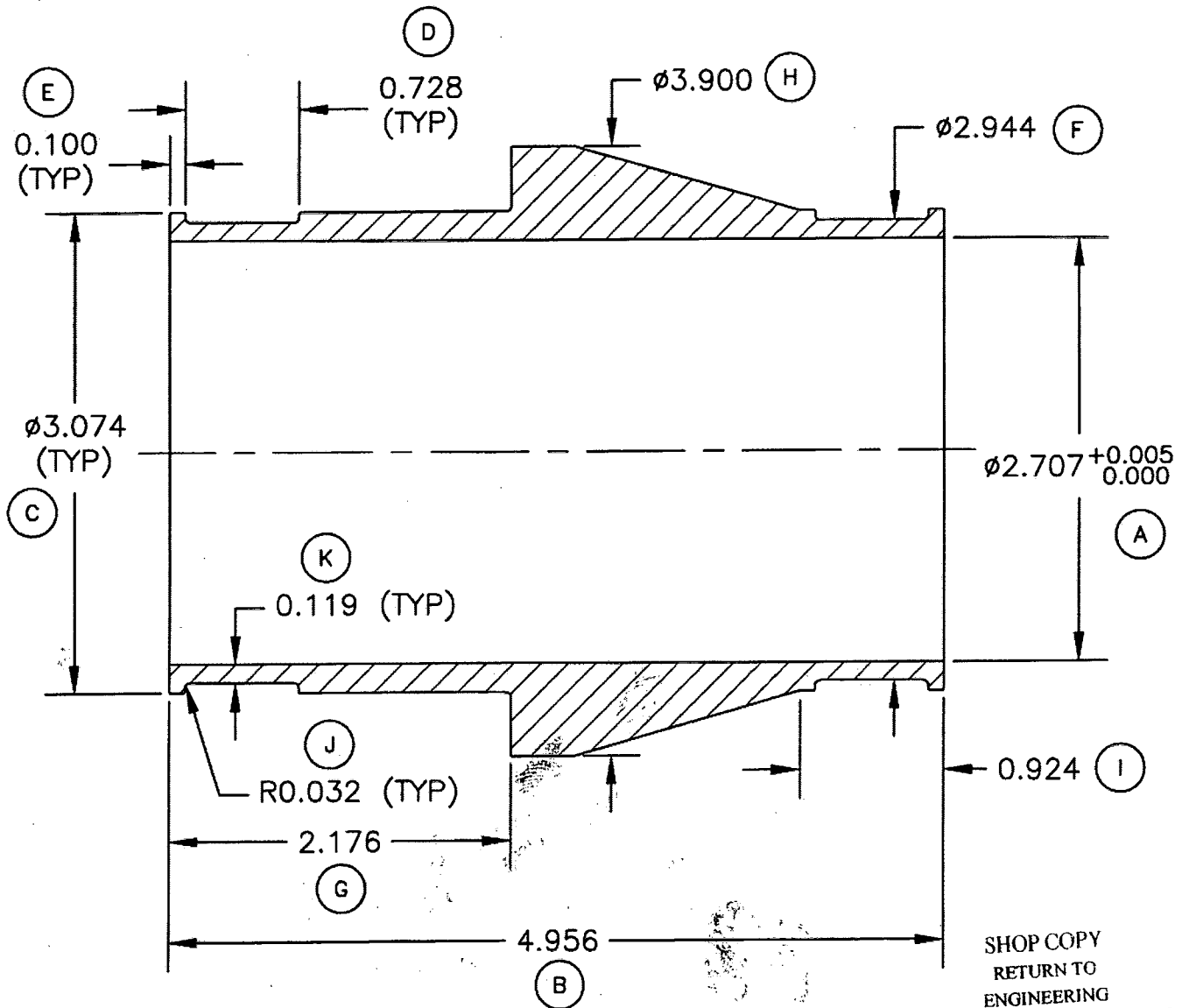
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

**RELEASED**  
03.07.01**D2893-1 TURNING DETAIL**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39539.

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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